DEPARTMENT OF TRANSPORTATION
DIVISION OF ENGINEERING SERVICES
Office of Structural Materials
Quality Assurance and Source Inspection

Bay Area Branch
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Contract #: 04-0120F4
Cty: SF/ALA Rte: 80 PM: 13.2/13.9
File #: 1.28

WELDING INSPECTION REPORT

Resident Engineer: Casey, William
Address: 333 Burma Road
City: Oakland, CA 94607

Report No: WIR-028700
Date Inspected: 30-Oct-2012

Project Name: SAS Superstructure
Prime Contractor: American Bridge/Fluor Enterprises, a JV
Contractor: American Bridge/Fluor Enterprises, a JV

OSM Arrival Time: 700
OSM Departure Time: 1730
Location: Job site

CWI Name:	N/A			**CWI Present:**	☑ Yes	☐ No		
Inspected CWI report:	☐ Yes	☑ No	☐ N/A	**Rod Oven in Use:**	☐ Yes	☐ No	☑ N/A	
Electrode to specification:	☐ Yes	☐ No	☑ N/A	**Weld Procedures Followed:**	☐ Yes	☐ No	☑ N/A	
Qualified Welders:	☐ Yes	☐ No	☑ N/A	**Verified Joint Fit-up:**	☐ Yes	☐ No	☑ N/A	
Approved Drawings:	☐ Yes	☐ No	☑ N/A	**Approved WPS:**	☐ Yes	☐ No	☑ N/A	
				Delayed / Cancelled:	☐ Yes	☑ No	☐ N/A	

Bridge No: 34-0006
Component: OBG

Summary of Items Observed:

Quality Assurance Inspector (QAI) Rodney Patterson was at the American Bridge/Fluor (ABF) job site at Yerba Buena Island in California between the times noted above in order to monitor Quality Control functions and the in process work being performed by ABF personnel. The following items were observed:

This QA performed verification Ultrasonic Testing (UT) on Complete Joint Penetration (CJP) Deck drop-in related welds for lift 5E, 12W and 13W. The welds were previously tested and accepted by QC Ultrasonic technicians in accordance with AWS D1.5-2002, section 6, table 6.3. The QAI's findings are as follows;

5W Deck Access Hole Splice (Weld No. DAH-5E-PP29.5-E5)
The QAI performed 100% verification of this weld. A total of five (5) rejectable indications were observed at the time of inspection. The rejectable indications were confirmed by ABF QC inspector Bernard Docena on the following shift.

12W Corner Drop-in Web Splice (Weld No. 12W-PP114.5-W2.1-BW2)
The QAI performed 25% verification of this weld from Y=0~350. No rejectable indications were observed at the time of inspection.

12W Corner Drop-in Web Splice (Weld No. 12W-PP115.5-W2.1-BW2)
The QAI performed in way of Y=1160 previously rejected by QA. No rejectable indications were observed at the time of inspection.

12W Corner Drop-in Web Splice (Weld No. 12W-PP116.5-W2.1-BW2)
The QAI performed 100% verification of this weld. No rejectable indications were observed at the time of inspection.

13W Deck Drop-in Transverse Splice (Weld No. 13W-PP122.2)
The QAI performed verification of this weld in way locations ultrasonically rejected during the QA recordable verification on 09-19-2012.The following Y locations were examined;

Y=1060 No rejectable indications were observed at the time of inspection
Y=1070 No rejectable indications were observed at the time of inspection
Y=4160 No rejectable indications were observed at the time of inspection
Y=6590 No rejectable indications were observed at the time of inspection
Y=6870 No rejectable indications were observed at the time of inspection

13W Deck Drop-in Longitudinal Splice (Weld No. 13W-W2.8)
The QAI performed verification of this weld in way locations ultrasonically rejected by the QAI on 09-18-2012. The following Y locations were examined;

Y=2440 No rejectable indications were observed at the time of inspection
Y=3125 No rejectable indications were observed at the time of inspection
Y=8590 No rejectable indications were observed at the time of inspection

The QAI was provided the approval for repair document history for this weld by the QA task leader, for ultrasonic verification and closure of the listed repair documents at the following locations;

Y=170 RWR-201208-084
Y=230 RWR-201208-085
Y=2090 RWR-201209-099
Y=2210 RWR-201209-80
Y=2450 RWR-201210-018
Y=3125 RWR-201210-018
Y=3280 RWR-201209-108
Y=8590 RWR-201210-015
Y=8820 RWR-201208-086
Y=11740 RWR-201208-087
Y=11780 RWR-201208-087
Y=11180 RWR-201209-034
Y=8570~12570 RWR-201208-001- Random verification performed in way of repair 4 Meters in length.

Magnetic Particle Testing (OBG 13W)
This QA Inspector performed verification Magnetic Particle Testing (MT) of the lift 12W, 13W Deck Drop-in connections. This QA Inspector generated a TL-6028 MT report on this date. The results of the inspection are as follows;

12W Corner Drop-in Web Splice (Weld No. 12W-PP114.5-W2.1-BW2)
The QAI performed 100% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

12W Corner Drop-in Web Splice (Weld No. 12W-PP115.5-W2.1-BW2)
The QAI performed 100% verification of this weld from face A/B. No rejectable indications were observed at the time of inspection.

13W Deck Drop-in Transverse Splice (Weld No. 13W-PP122.2)
The QAI performed verification of this weld in way of the following Y locations;

Y=1060 No rejectable indications were observed at the time of inspection
Y=1070 No rejectable indications were observed at the time of inspection
Y=4160 No rejectable indications were observed at the time of inspection
Y=6590 No rejectable indications were observed at the time of inspection
Y=6870 No rejectable indications were observed at the time of inspection

13W Deck Drop-in Longitudinal Splice (Weld No. 13W-W2.8)
The QAI was provided the approval for repair document history for this weld by the QA task leader, for Magnetic Particle verification and closure of the listed repair documents at the following locations from face A/B;

Y=170 RWR-201208-084
Y=230 RWR-201208-085
Y=2090 RWR-201209-099
Y=2210 RWR-201209-80
Y=2450 RWR-201210-018
Y=3125 RWR-201210-018
Y=3280 RWR-201209-108
Y=8590 RWR-201210-015
Y=8820 RWR-201208-086
Y=11740 RWR-201208-087
Y=11780 RWR-201208-087
Y=11180 RWR-201209-034
Y=8570~12570 RWR-201208-001- Random verification performed in way of repair 4 Meters in length.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Conversations relevant to the work being performed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Gary Thomas (916) 764-6027, who represents the Office of Structural Materials for your project.

WELDING INSPECTION REPORT

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Inspected By:	Patterson,Rodney	Quality Assurance Inspector
Reviewed By:	Reyes,Danny	QA Reviewer